

Date: Wednesday, 19/12/2007 3:38:06 PM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLIP  
Job Number : 36455  
Estimate Number : 12538  
P.O. Number : N/A Part Number : D35461  
This Issue : 19/12/2007 S.O. No. : N/A Drawing Number : D3546 REV A  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
Previous Run : 35150 Material : N/A  
Due Date : 26/12/2007 Qty: 20 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 06-09-27 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S18GA 304/316 .050 Sheet



Comment: Qty.: 0.2205 sf(s)/Unit Total : 4.4100 sf(s)

304 SS SHEET 18GA

Batch: 100997 1807-12-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3546

Dwg Rev: A

Prog Rev: A

1807-12-19

20

2-Deburr if necessary

1807-12-19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



1807-12-19

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

6 07/12/20

170

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3546

SB 07/12/20 20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLIP

Job Number: 36455

Part Number: D35461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 4/2/21 x20

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FR 07/12/27

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JS 07/12/27 x20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 108

JS 07/12/27

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 08/01/03

Job Completion



mi 2008/1/2

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

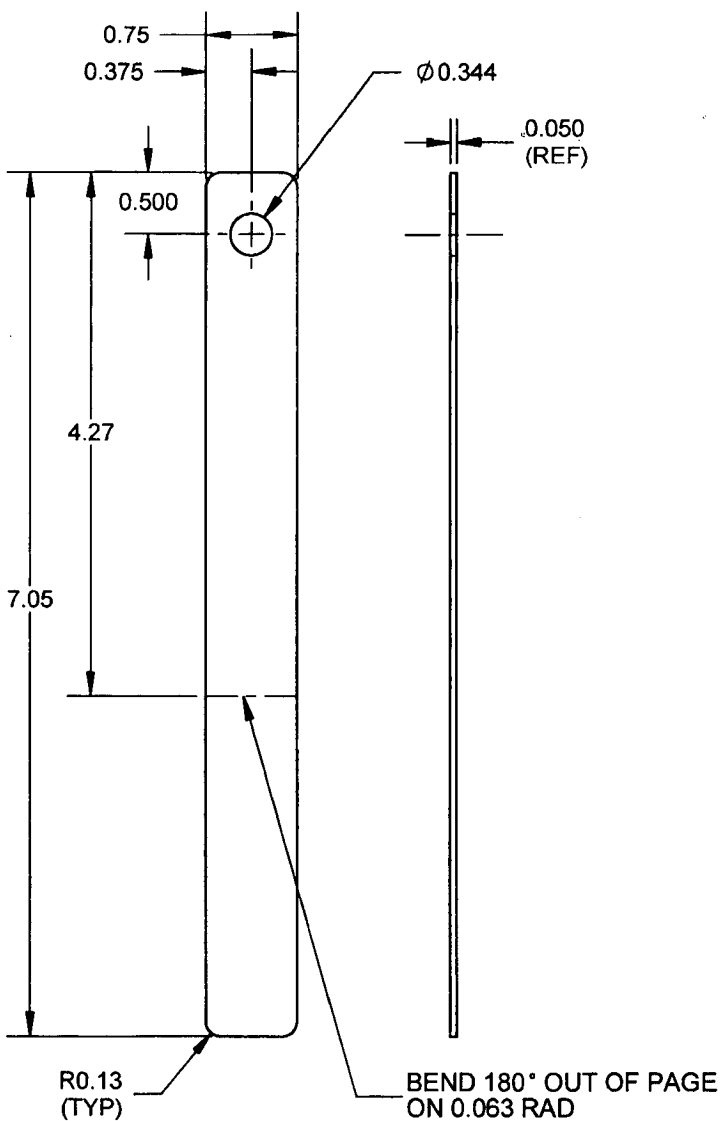
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

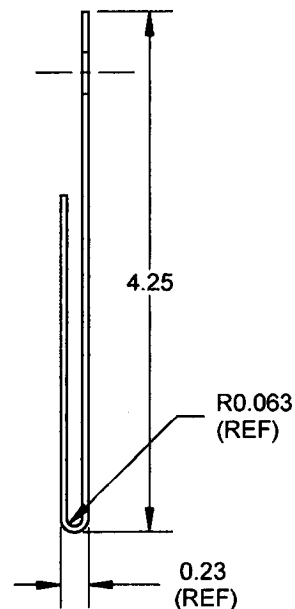
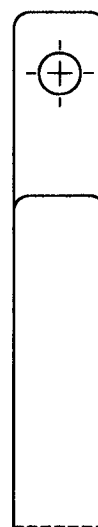
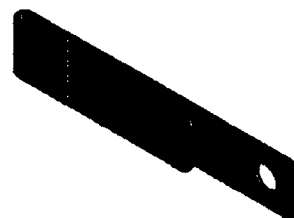
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3546</b>	REV. A SHEET 1 OF 1
DATE <b>06.09.15</b>	TITLE <b>CLIP</b> SCALE 1:1		
REV	DATE	DESCRIPTION	
A	06.09.15	NEW ISSUE	



**D3546-1F FLAT PATTERN**



**D3546-1 CLIP**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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*WLD 30455*

